AMENDMENT

(Amendment Based on Article 11)

To: The Examiner of the Japanese Patent Office

1. Identification of the International Application

PCT/JP03/08332

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4. Item to be amended: Claims

5. Contents of Amendment:

(1) The expression "a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.6/1000," on page 37 line 6 in Claim 1 should be amended as "a mold whose cavity is designed to set X direction, Y direction, and Z direction molding shrinkage ratios of said resin molded article to be the same value each into a range of between 4.5/1000 and 6.6/1000,".

(2) The expression "a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.7/1000," on page 37 line 17 in Claim 2 should be amended as "a mold whose cavity is designed to set X direction, Y direction, and Z direction molding shrinkage ratios of said resin molded article to be the same value each into a range of between 4.5/1000

[Table 2]

Resin = ABS Table 2-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS Table 2-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = ABS Table 2-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = ABS Table 2-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.5

Resin = ABS Table 2-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = ABS Table 2-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.0

Resin = ABS Table 2-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.4

Resin = ABS Table 2-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = ABS Table 2-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	120
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS Table 2-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	10
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = ABS Table 2-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = ABS Table 2-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	45
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

[Table 3]

Resin = HIPS — Table 3-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = HIPS — Table 3-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS — Table 3-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = HIPS — Table 3-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	15
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = HIPS — Table 3-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = HIPS — Table 3-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	65
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS — Table 3-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = HIPS — Table 3-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = HIPS — Table 3-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	120
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = HIPS — Table 3-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	10
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = HIPS — Table 3-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = HIPS — Table 3-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	38
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

[Table 4]

Resin = modified PPE — Table 4-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.5

Resin = modified PPE — Table 4-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = modified PPE — Table 4-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.4

Resin = modified PPE — Table 4-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	15
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.5

Resin = modified PPE — Table 4-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = modified PPE — Table 4-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	65
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.1

Resin = modified PPE — Table 4-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.5

Resin = modified PPE — Table 4-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = modified PPE — Table 4-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	120
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = modified PPE — Table 4-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	10
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = modified PPE — Table 4-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = modified PPE — Table 4-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	245
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	40
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

[Table 5]

Resin = ABS
Foaming agent = AC

Table 5-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = ABS
Foaming agent = AC

Table 5-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = ABS
Foaming agent = AC

Table 5-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.2

Resin = ABS
Foaming agent = AC

Table 5-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = ABS
Foaming agent = AC

Table 5-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = ABS
Foaming agent = AC

Table 5-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = ABS
Foaming agent = AC

Table 5-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = ABS
Foaming agent = AC

Table 5-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = ABS
Foaming agent = AC

Table 5-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.2

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-13

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-14

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-15

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-16

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-17

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = ABS
Foaming agent = Sodium hydrogen carbonate

Table 5-18

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

[Table 6]

Resin = HIPS
Foaming agent = AC

Table 6-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = HIPS
Foaming agent = AC

Table 6-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = HIPS
Foaming agent = AC

Table 6-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = HIPS
Foaming agent = AC

Table 6-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = HIPS
Foaming agent = AC

Table 6-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = HIPS
Foaming agent = AC

Table 6-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = HIPS
Foaming agent = AC

Table 6-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = HIPS
Foaming agent = AC

Table 6-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = HIPS
Foaming agent = AC

Table 6-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-13

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-14

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-15

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.2

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-16

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-17

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = HIPS
Foaming agent = Sodium hydrogen carbonate

Table 6-18

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

[Table 7]

Resin = modified PPE
Foaming agent = AC

Table 7-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = modified PPE
Foaming agent = AC

Table 7-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = modified PPE
Foaming agent = AC

Table 7-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = modified PPE
Foaming agent = AC

Table 7-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = modified PPE
Foaming agent = AC

Table 7-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = modified PPE
Foaming agent = AC

Table 7-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = modified PPE
Foaming agent = AC

Table 7-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = modified PPE
Foaming agent = AC

Table 7-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = modified PPE
Foaming agent = AC

Table 7-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.5

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-13

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-14

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-15

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.4

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-16

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-17

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = modified PPE
Foaming agent = Sodium hydrogen carbonate

Table 7-18

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.5

[Table 8]

Resin = AES
Foaming agent = AC

Table 8-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = AES
Foaming agent = AC

Table 8-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = AES
Foaming agent = AC

Table 8-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = AES
Foaming agent = AC

Table 8-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	15
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.7

Resin = AES
Foaming agent = AC

Table 8-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = AES
Foaming agent = AC

Table 8-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	65
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.1

Resin = AES
Foaming agent = AC

Table 8-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	90
Molding Shrinkage ratio (X,Y,Z)	‰	7.3

Resin = AES
Foaming agent = AC

Table 8-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	180
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

Resin = AES
Foaming agent = AC

Table 8-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	35
Injection pressure	%	99
Injection speed	%	99
Cooling time of the inside of the mold	sec	360
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

[Table 9]

Resin = ABS

Table 9-1

Item		Unit	Value in Practice
The temprature		°C	230
The temprature		°C	45
Injection pressure		%	70
Injection speed		%	70
Holding pressure		%	25
Holding time		sec	3
Cooling time		sec	25
Molding Shrinkage ratio	X axis direction	‰	5.2 to 5.4
	Y axis direction	‰	5.3 to 5.6
	Z axis direction	‰	6.2 to 6.9

Resin = modified PPE

Table 9-2

Item		Unit	Value in Practice
The temprature		°C	210
The temprature		°C	45
Injection pressure		%	70
Injection speed		%	70
Holding pressure		%	25
Holding time		sec	3
Cooling time		sec	25
Molding Shrinkage ratio	X axis direction	‰	5.4 to 5.8
	Y axis direction	‰	5.2 to 5.5
	Z axis direction	‰	6.1 to 6.9

Resin = HIPS

Table 9-3

Item		Unit	Value in Practice
The temprature		°C	240
The temprature		°C	45
Injection pressure		%	70
Injection speed		%	70
Holding pressure		%	25
Holding time		sec	3
Cooling time		sec	25
Molding Shrinkage ratio	X axis direction	‰	5.4 to 5.7
	Y axis direction	‰	5.3 to 5.5
	Z axis direction	‰	6.2 to 7.0

Resin = PC/ABS

Table 9-4

Item		Unit	Value in Practice
The temprature		°C	230
The temprature		°C	45
Injection pressure		%	70
Injection speed		%	70
Holding pressure		%	25
Holding time		sec	3
Cooling time		sec	25
Molding Shrinkage ratio	X axis direction	‰	5.0 to 5.3
	Y axis direction	‰	4.9 to 5.1
	Z axis direction	‰	5.6 to 6.5

[Table 10]

Resin = PC/ABS — Table 10-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.1

Resin = PC/ABS — Table 10-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = PC/ABS — Table 10-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.4

Resin = PC/ABS — Table 10-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	15
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.4

Resin = PC/ABS — Table 10-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = PC/ABS — Table 10-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	65
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = PC/ABS — Table 10-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = PC/ABS — Table 10-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = PC/ABS — Table 10-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	120
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = PC/ABS — Table 10-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	10
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = PC/ABS — Table 10-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = PC/ABS — Table 10-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	210
The temprature of the mold	°C	35
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	45
Gass pressure	Mpa	38
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

[Table 11]

Resin = ABS — Table 11-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS — Table 11-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = ABS — Table 11-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS — Table 11-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = HIPS — Table 11-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS — Table 11-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = modified PPE — Table 11-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = modified PPE — Table 11-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = modified PPE — Table 11-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.4

[Table 12]

Resin = ABS in which AnSt-g-BR is added — Table 12-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS in which AnSt-g-BR is added — Table 12-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = ABS in which AnSt-g-BR is added — Table 12-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.3

Resin = ABS in which AnSt-g-EPDM is added — Table 12-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.1

Resin = ABS in which AnSt-g-EPDM is added — Table 12-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.9

Resin = ABS in which AnSt-g-EPDM is added — Table 12-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = ABS in which AnSt-g-AR is added — Table 12-7

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS in which AnSt-g-AR is added — Table 12-8

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.8

Resin = ABS in which AnSt-g-AR is added — Table 12-9

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.1

Resin = HIPS in which St-g-BR is added — Table 12-10

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.1

Resin = HIPS in which St-g-BR is added — Table 12-11

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS in which St-g-BR is added — Table 12-12

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.9

Resin = HIPS in which St-g-EPDM is added — Table 12-13

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.1

Resin = HIPS in which St-g-EPDM is added — Table 12-14

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.1

Resin = HIPS in which St-g-EPDM is added — Table 12-15

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.8

Resin = HIPS in which Perprene P-150B is added — Table 12-16

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = HIPS in which Perprene P-150B is added — Table 12-17

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.2

Resin = HIPS in which Perprene P-150B is added — Table 12-18

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	7.0

[Table 13]

Resin = PPE modified HIPS in which St-g-B is added — Table 13-1

Item	Unit	Value in Practice
The temprature of the melting resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.5

Resin = PPE modified HIPS in which St-g-B is added — Table 13-2

Item	Unit	Value in Practice
The temprature of the melting resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = PPE modified HIPS in which St-g-B is added — Table 13-3

Item	Unit	Value in Practice
The temprature of the melting resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = PPE modified HIPS in which St-g-E is added — Table 13-4

Item	Unit	Value in Practice
The temprature of the melting resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = PPE modified HIPS in which St-g-E is added — Table 13-5

Item	Unit	Value in Practice
The temprature of the melting resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = PPE modified HIPS in which St-g-E is added — Table 13-6

Item	Unit	Value in Practice
The temprature of the melting resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

Resin = PPE modified HIPS in which Perprene P-150B is added — Table 13-7

Item	Unit	Value in Practice
The temprature of the melting resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.4

Resin = PPE modified HIPS in which — Table 13-8

Item	Unit	Value in Practice
The temprature of the melting resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	5.6

Resin = PPE modified HIPS in which — Table 13-9

Item	Unit	Value in Practice
The temprature of the melting resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position	Cavity	
Molding Shrinkage ratio (X,Y,Z)	‰	6.6

[Table 14]

Resin = ABS — Table 14-1

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.2

Resin = ABS — Table 14-2

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.7

Resin = ABS — Table 14-3

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.3

Resin = HIPS — Table 14-4

Item	Unit	Value in Practice
The temprature of the melted resin	°C	180
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	5.1

Resin = HIPS — Table 14-5

Item	Unit	Value in Practice
The temprature of the melted resin	°C	230
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.3

Resin = HIPS — Table 14-6

Item	Unit	Value in Practice
The temprature of the melted resin	°C	265
The temprature of the mold	°C	45
Injection pressure	%	70
Injection speed	%	70
Cooling time of the inside of the mold	sec	15
Gass pressure	Mpa	25
Gas injection position		Cavity
Molding Shrinkage ratio (X,Y,Z)	‰	6.8